

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

May-31-12 3:13:32 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

*** 1 ***

Customer:

*** 1 ***

Reference:

Run Start *NR1*

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Insp.
Stamp

130

130

Brake NC

Brake NC

NC BRAKE

Memo

Bend as per dwg D2196

0.00

0.00

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0,00

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

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Work Order ID 85035

85035

Page 3

May-31-12 3:13:32 PM

Item ID: D2196-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 31/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/6/12

MF
12-06-06

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Picklist Print

May-31-12 3:13:36 PM

Page 1

Work Order ID: 85035

85035

Parent Item: D2196-1

D2196-1

Parent Item Name: Bracket

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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No

**

**

0.4016 sf

304 0.063"

B# 121626

Jm
12-6-01

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DART AEROSPACE LTD		Work Order:	85035
Description: Bracket		Part Number:	D2196-1
Inspection Dwg: D2196 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128"	✓		✓	mm01
Ø0.203	+0.005/-0.001	0.203"	✓		✓	
Ø0.316	+0.006/-0.001	0.316"	✓		✓	
0.375	+/-0.010	0.382"	✓		✓	
0.813	+/-0.010	0.810"	✓		✓	
1.750	+/-0.010	1.758"	✓		✓	
2.688	+/-0.010	2.689"	✓		✓	
3.625	+/-0.010	3.630"	✓		✓	
4.000	+/-0.010	4.009"	✓		✓	
0.375	+/-0.010	0.379"	✓		✓	
1.200	+/-0.010	1.207"	✓		✓	
2.390	+/-0.010	2.394"	✓		✓	
3.960	+/-0.010	3.963"	✓		✓	
5.530	+/-0.010	5.539"	✓		✓	
6.730	+/-0.010	6.723"	✓		✓	
7.230	+/-0.010	7.232"	✓		✓	

Measured by:	JM	Audited by:	S	Prototype Approval:	N/A
Date:	12-6-01	Date:	12/06/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	

Dart Aerospace Ltd

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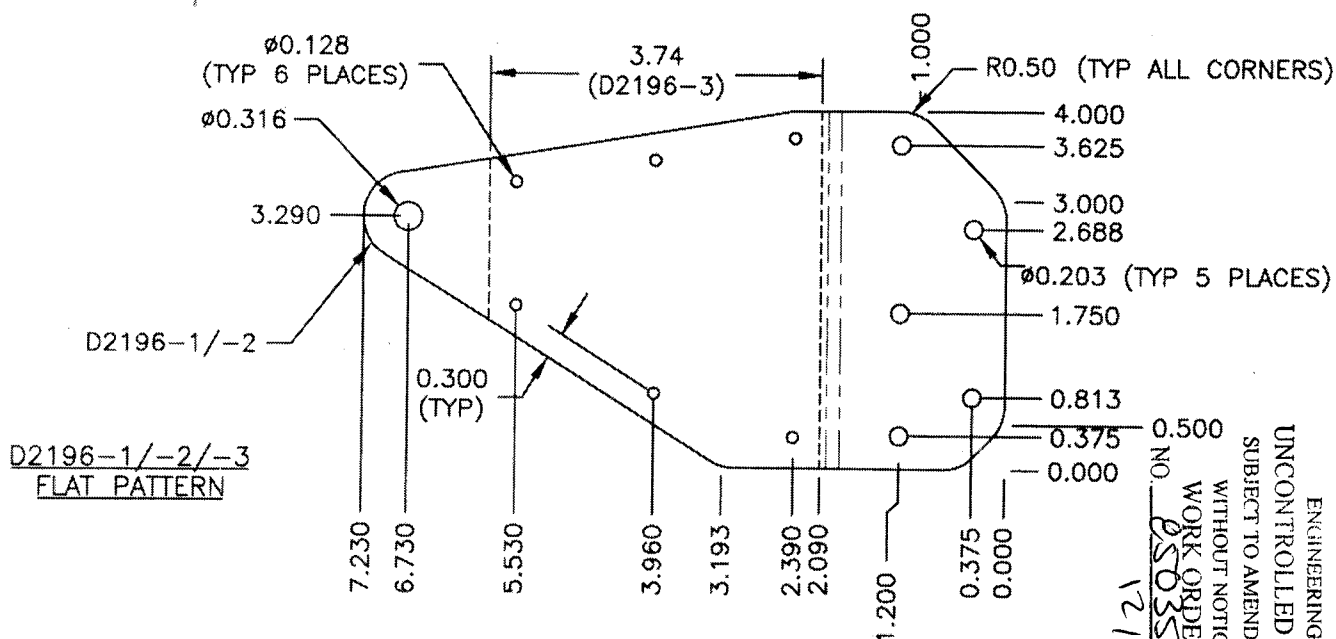
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2196	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK	

RELEASED
03 07 09



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

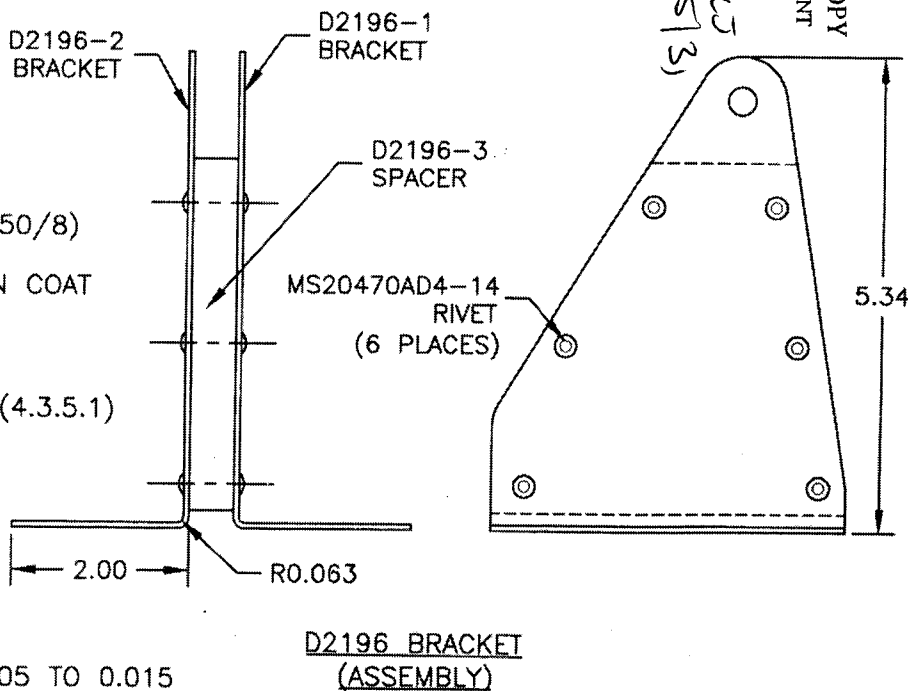
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 05035M45
12/05/3

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